

Tuesday, 1/3/2006 4:18:27 PM
Kim Johnston

SPLIT

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARPAW KIT (19"X24")
Job Number	: 25367 B		
Estimate Number	: 10323	Part Number	: K10008
P.O. Number	: N/A	Drawing Number	: D2432 REV F3
This Issue	: 1/3/2006 S.O. No. : N/A	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: F3
First Issue	: N/A Type : MACHINED PARTS	Material	: N/A
Previous Run	: 24965	Due Date	: 1/30/2006
Written By	: SEE COMMENT BELOW	Qty:	73 Um: Each
Checked & Approved By	: SEE COMMENT BELOW		
Comment	: Est Rev:J 04.02.17 Blank size changed KJ/JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile:

K10008

D206-559-013

D350-578-011

D315-670-011

D427-659-011

and create labels per PPP K10008

CHG006(Bag Bluefiles separately)

Dt. 06/01/04

2.0 MUHMB10 UHMW 1" Black



Comment: Qty.: 6.8250 sf(s)/Unit Total: 136.5000 sf(s)
 blank: 19.500" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5
 Material: Black UHMW 1"
 (MUHMB10)
 Batch: **1119541**

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Note:(2) bearpaws for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2432 Identify as D2432F

3-Deburr

/SD 06.01.19

7

Process Sheet

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Part Number: K10008

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Seq. #: Machine Or Operation: Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

15A

06.01.19

7

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

36

06.01.19

7

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty: 0.4160 f(s)/Unit Total: 8.3200 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2182B050

Rubber Cushion

B23172

8.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total: 240.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2274

Radius Block

B24872

2 D2432F(ref only)

Bearpaw

B23367

~~Stock 1 D2432~~

9.0

D2438

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total: 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2438

Clamp

B23818



Process Sheet

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Drawing Name: BEARPAW KIT (19"X24")

Job Number: 25367

Part Number: K10008

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 240.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2529 Washer B23177

11.0

D2732

Rubber Extrusion



Comment: Qty.: 0.4160 Each(s)/Unit Total : 8.3200 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2732-050 Rubber Cushion 24182

12.0

AN415A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 240.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-15A Bolt M19085

13.0

AN417A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 240.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-17A Bolt M15432

14.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 480.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

24 AN960JD416 Washer M18431



Process Sheet

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Drawing Name: BEARPAW KIT (19"X24")

Job Number: 25367

Part Number: K10008

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 240.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4

Nut (or -4)

17997

PU 6/1/28

277

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

C206/01/20

(3) 1/2

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPK10008

Location:

Done PU 6/1/19

(3) 1/2

18.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/01/20 (3)

SP06/01/20

Job Completion



DART AEROSPACE LTD		Work Order:	25367
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432	Rev: F3	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.055 x 45°	/			
B	5.500	+/-0.030	5.503	/			
C	0.200	+/-0.030	.296	/			
D	0.25 x 45°	+/-0.030	.220 x 45°	/			
E	R0.250	+/-0.030	R.250	/			
F	0.250	+/-0.010	.252	/			
G	0.625	+/-0.030	.623	/			
H	0.375	+/-0.010	.377	/			
I	0.950	+0.030/0.010	.946	/			
J	19.000	+/-0.030	19.00	/			
K	3.14	+/-0.030	3.122	/			
L	3.28	+/-0.030	3.272	/			
M	Ø0.260	+0.005/-0.000	Ø.260	/			
N	Ø0.93	+/-0.030	Ø.930	/			
O	0.30	+0.030/-0.000	.300	/			
P	23.750	+/-0.030	23.750	/			
Q	7.375	+/-0.030	7.375	/			
R	4.250	+/-0.010	4.250	/			
S	2.000	+/-0.030	2.000	/			
T	9.000	+/-0.010	9.000	/			
U	9.000	+/-0.010	9.000	/			
V	0.375	+/-0.010	.378	/			

Measured by: SA	Audited by: JG	Prototype Approval:	N/A
Date: 06.01.19	Date: 06.01.19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	KJ/RF	

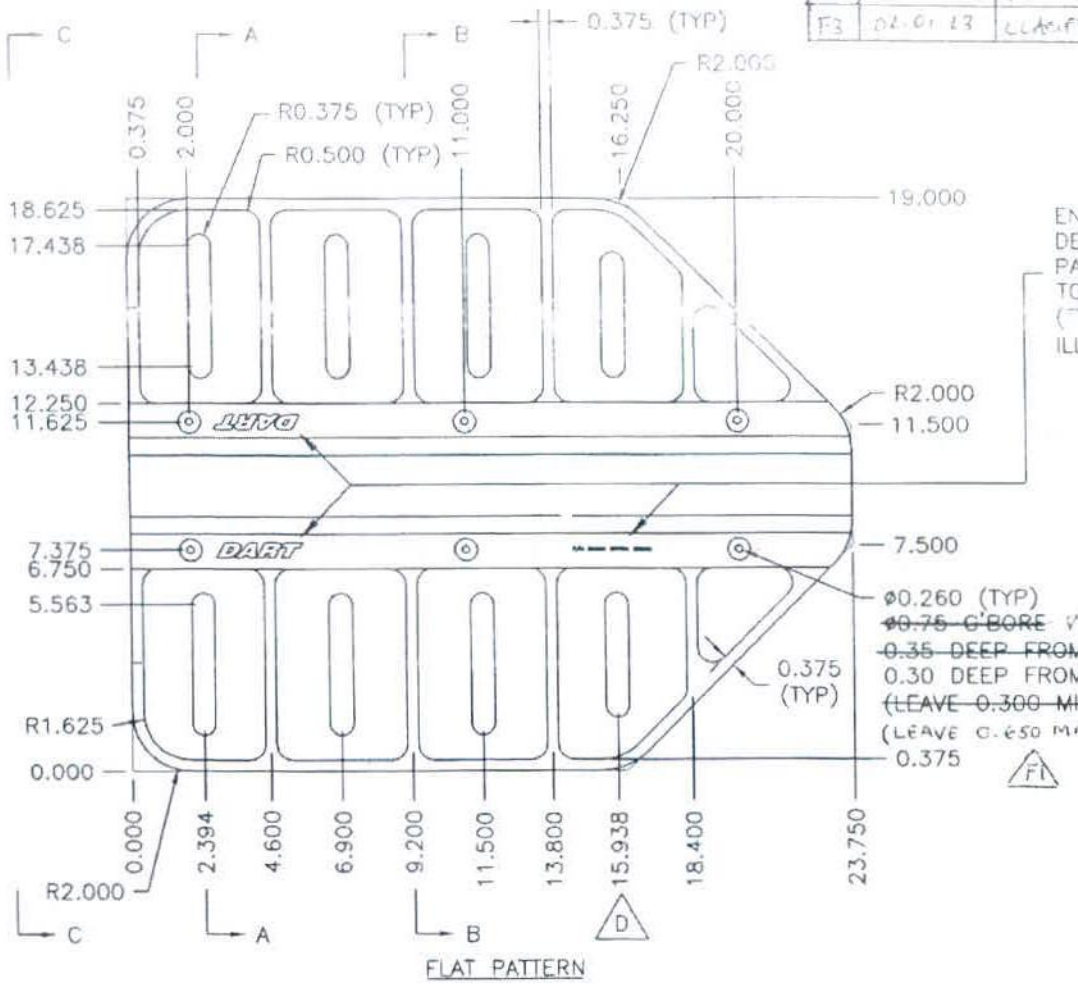


RELEASED
98.05.17 KG

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED: KE	APPROVED: KE	
DATE: 98.05.12	DRAWING NO.: D2432	REV. F
	TITLE: BEARPAW	SHEET 1 OF 2
		SCALE: 1:6

A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)



EFFECTIVE	DEOS
9143	

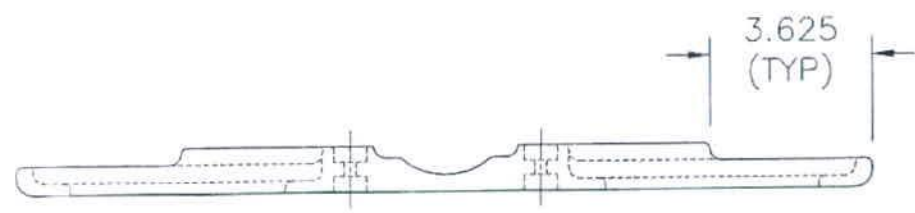
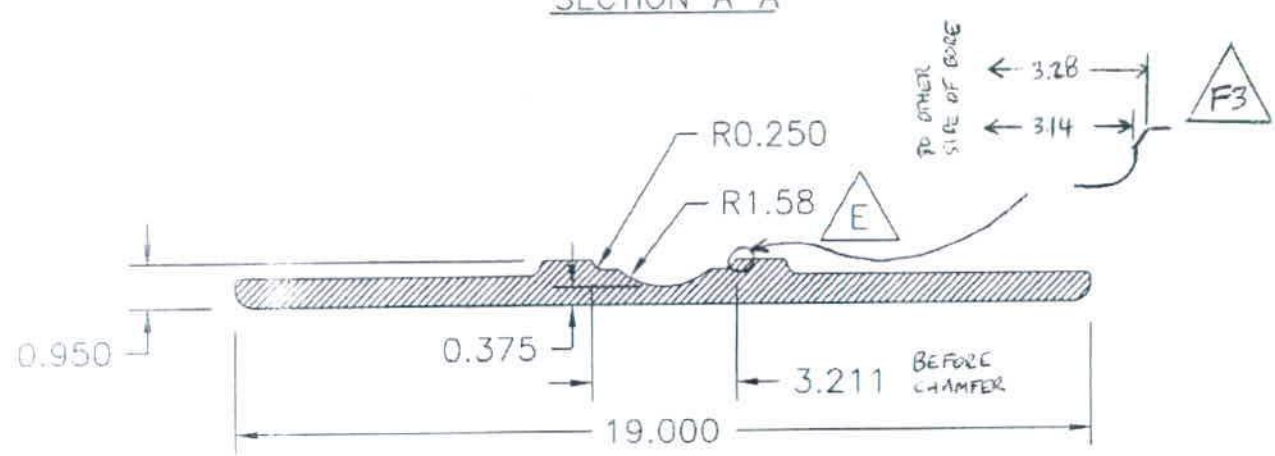
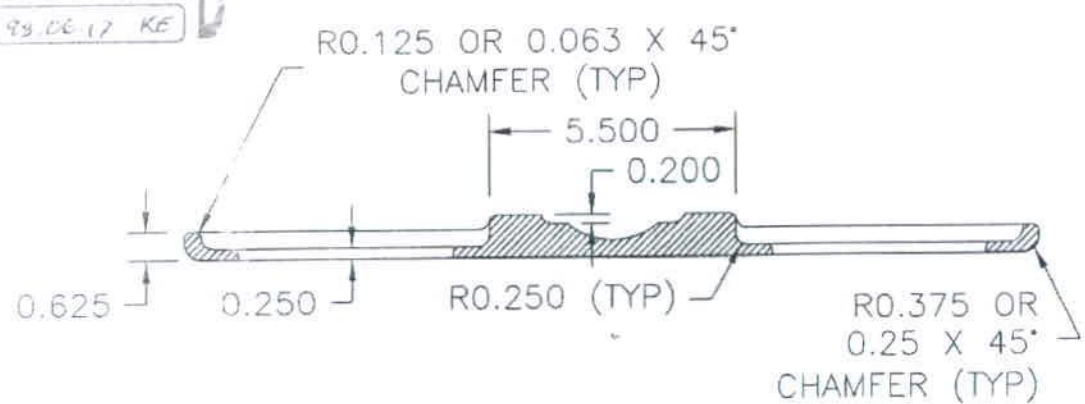
D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

RELEASED
98.06.17 KE



25367

